

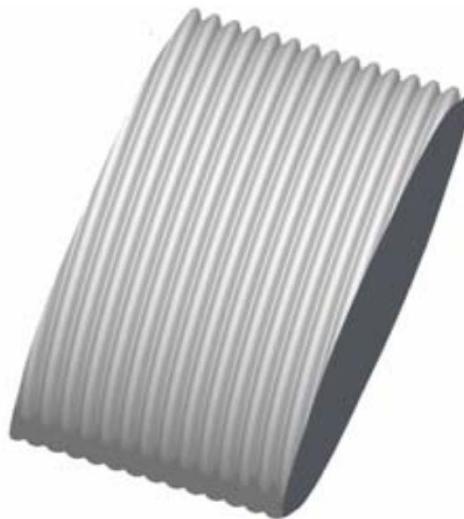
Cylindrical Thread Rolling Die

A21-010

HSS Cylindrical Thread Rolling
Die production with CBN
wheels.

Wheel No. 1 CBN three profile
wheel.

Wheel No. 2 CBN single profile
wheel



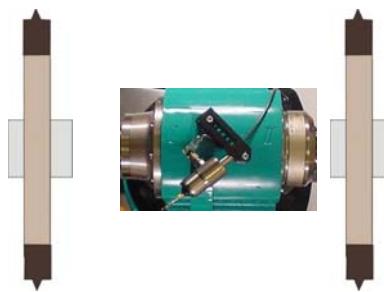
1. Cycletime for Production

Workpiece: Ø178 L76 Z310 P1.805 Helix 21° Material HSS		
Operations	MainThread	MainThread
Feed [mm/Min]	250	450
Increments [tot./part.]	0.2/0.02	0.01/0.01
Cutting speed [m/s]	38	40
Used wheels		
Grinding time [s]	1941	3099
Total cycle time	84 Min	

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	DXF Ø200 B106
2	DXF Ø200 B46



1

2

3. Machine and Software Requirements

Machines: 5 axes CNC grinders : NORMACfg

Coolant: Synthetic Oil, pressure 10 bar

Control: Fanuc 31i

Software: Quinto 5

Accessories:

Responsible engineer: OP, 25.5.13

www.schneeberger.ch

J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland

Subsidiaries in: France, Germany, Italy, United States, China